

Date: Thursday, 18/09/2008 11:12:47 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	TOP PANEL ASS'Y		
Job Number	42097			Part Number	D36509		
Estimate Number	13034			Drawing Number	D3650 REV.B		
P.O. Number				Project Number	N/A		
This Issue	18/09/2008	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	25/09/2008	Qty:	5
Previous Run	39951			Um:	Each		
Written By							
Checked & Approved By	JUL 08.9.18						
Comment	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD verified by: EC Est Rev:C ecn1162 08-04-02 DD verified by: EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
 Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.2678 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: 108418 MR 8-9-22		
2.0	WATER JET	FLOW WATER JET
 Comment: FLOW WATER JET 1-Cut as per Dwg D3650 Dwg Rev: B MR 8-9-22 Prog Rev: B		
2-Deburr if necessary MR 8-9-22		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 Comment: INSPECT PARTS AS THEY COME OFF MACHINE MR 8-9-22		
4.0	QC8	SECOND CHECK
 Comment: SECOND CHECK MR 8-9-22		
5.0	BRAKE NC	NC BRAKE
 Comment: NC BRAKE Form as per Dwg D3650 MR 8-9-22		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:12:48 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANEL ASS'Y

Job Number: 42097

Part Number: D36509

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



8 08/08/08 (X7)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: ST 115

AS 08/09/23 (X7)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/24 (X8)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42097
Description: Angle	Part Number:	D3650-9
Inspection Dwg: D3650	Rev: B	Page 1 of 1

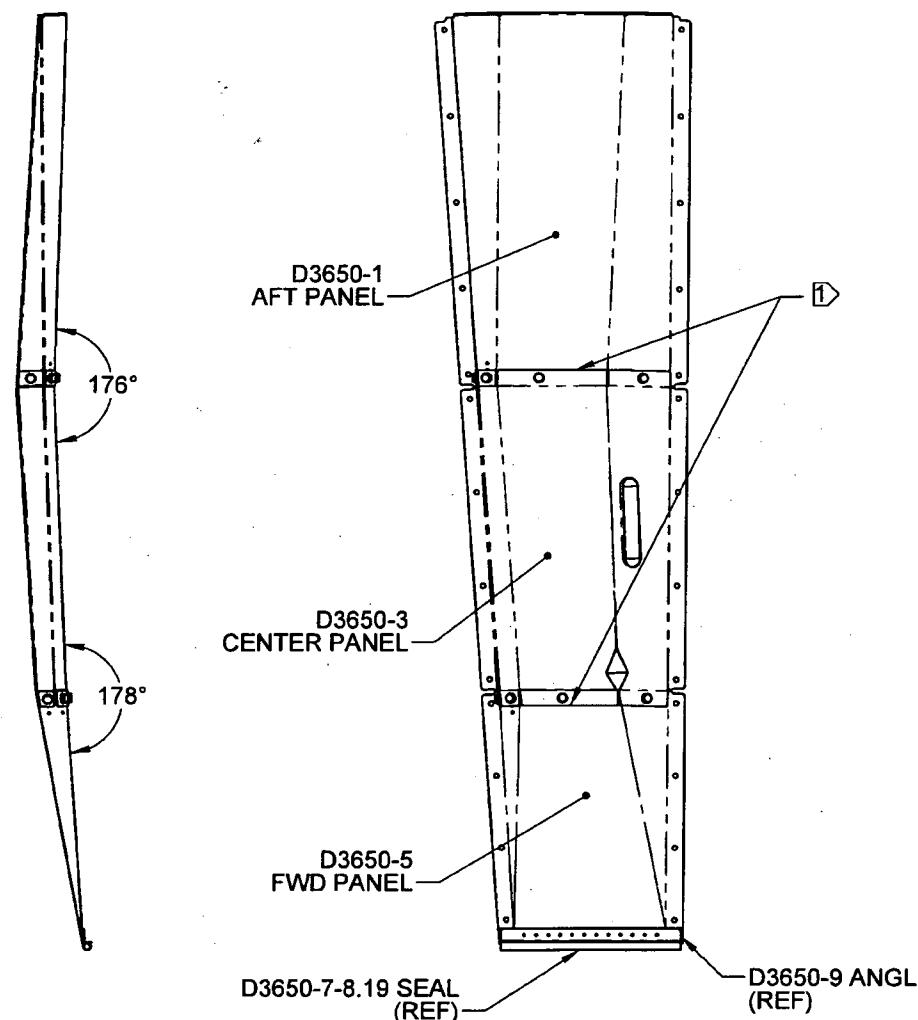
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

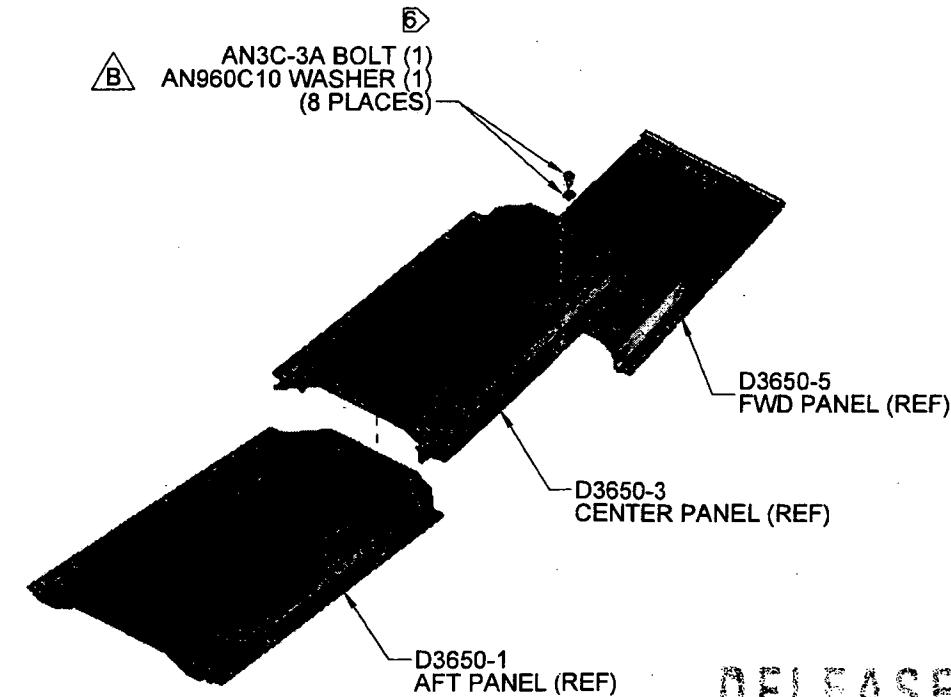
Measured by: <u>DB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>8-9-22</u>	Date: <u>08/09/22</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	

8 7 6 5 4 3 2 1

**D3650-041 TUNNEL TOP PANEL ASSEMBLY****NOTES:**

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

**PART LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

B SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES;
UPDATED VIEWS
SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED
VIEWS
SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW;
ADDED NOTE 8
SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS;
UPDATED VIEWS
SHEET 6: REMOVED/RELOCATED HOLES & ADDED
CUTOUT TO D3650-3F; MOVED D3650-11-11F TO SHEET 9;
ADDED DETAIL 1
SHEET 9: RELOCATED D3650-11-11F FROM SHEET 6;
UPDATED DIMS OF D3650-11-11F

RF 08.01.07

A NEW ISSUE RF 07.11.07

REV. DESCRIPTION BY DATE

DESIGN RF DART AEROSPACE LTD

DRAWN RF HAWKESBURY, ONTARIO, CANADA

CHECKED *LE* DRAWING NO. REV. BMFG. APPR. *MA* D3650 SHEET 1059 COPYAPPROVED *MM* TITLE *TOP PANEL ASSEMBLY* SCALE 1:100 TO ENGINEERINGDE APPR. *MM* DATE 08.01.07 CONTROLLED COPY SUBJECT TO AMENDMENT

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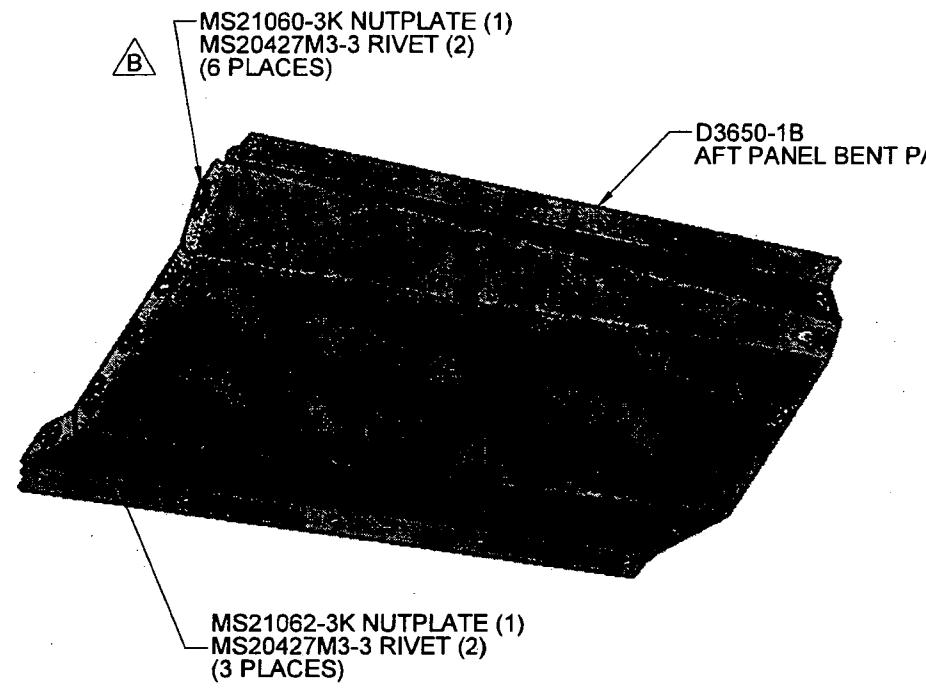
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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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WITHOUT NOTICE
WORK ORDER
NO. 040917

8 7 6 5 4 3 2 1



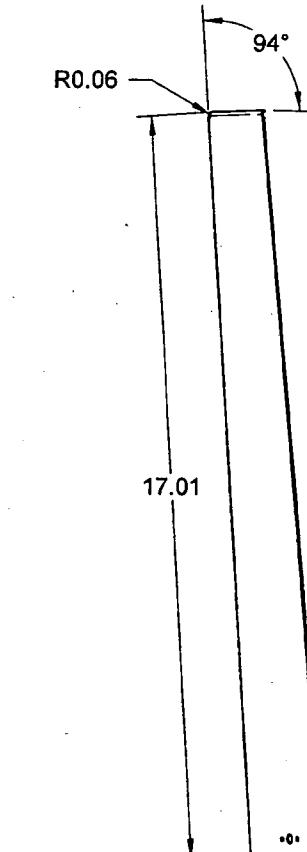
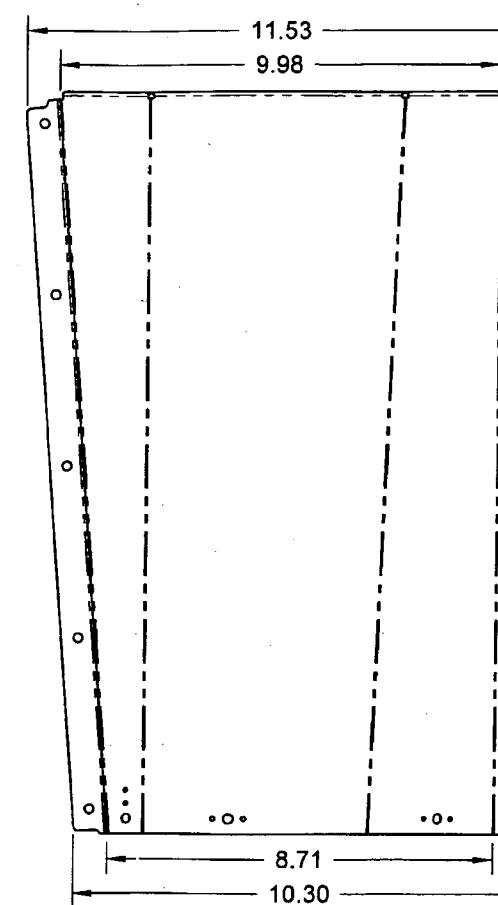
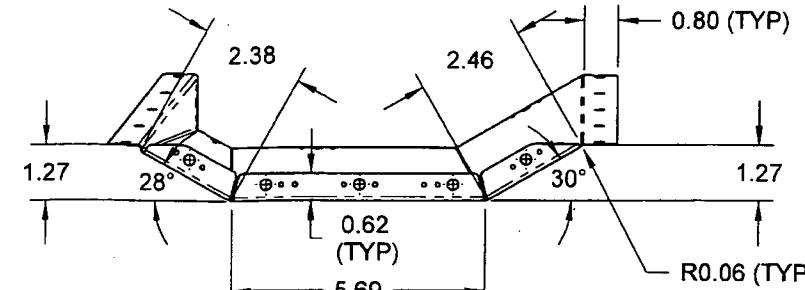
D3650-1 AFT PANE

PART LIST

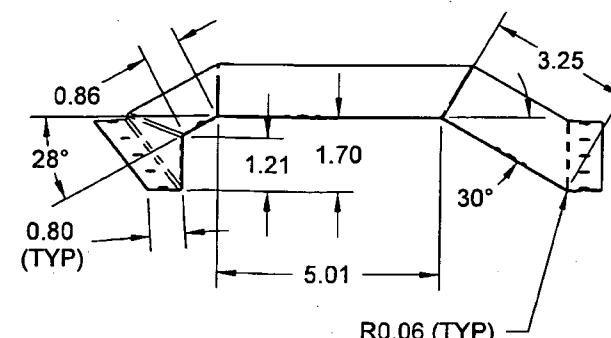
QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

NOTES

- 1) FINISH: NONE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: 1.3 lbs



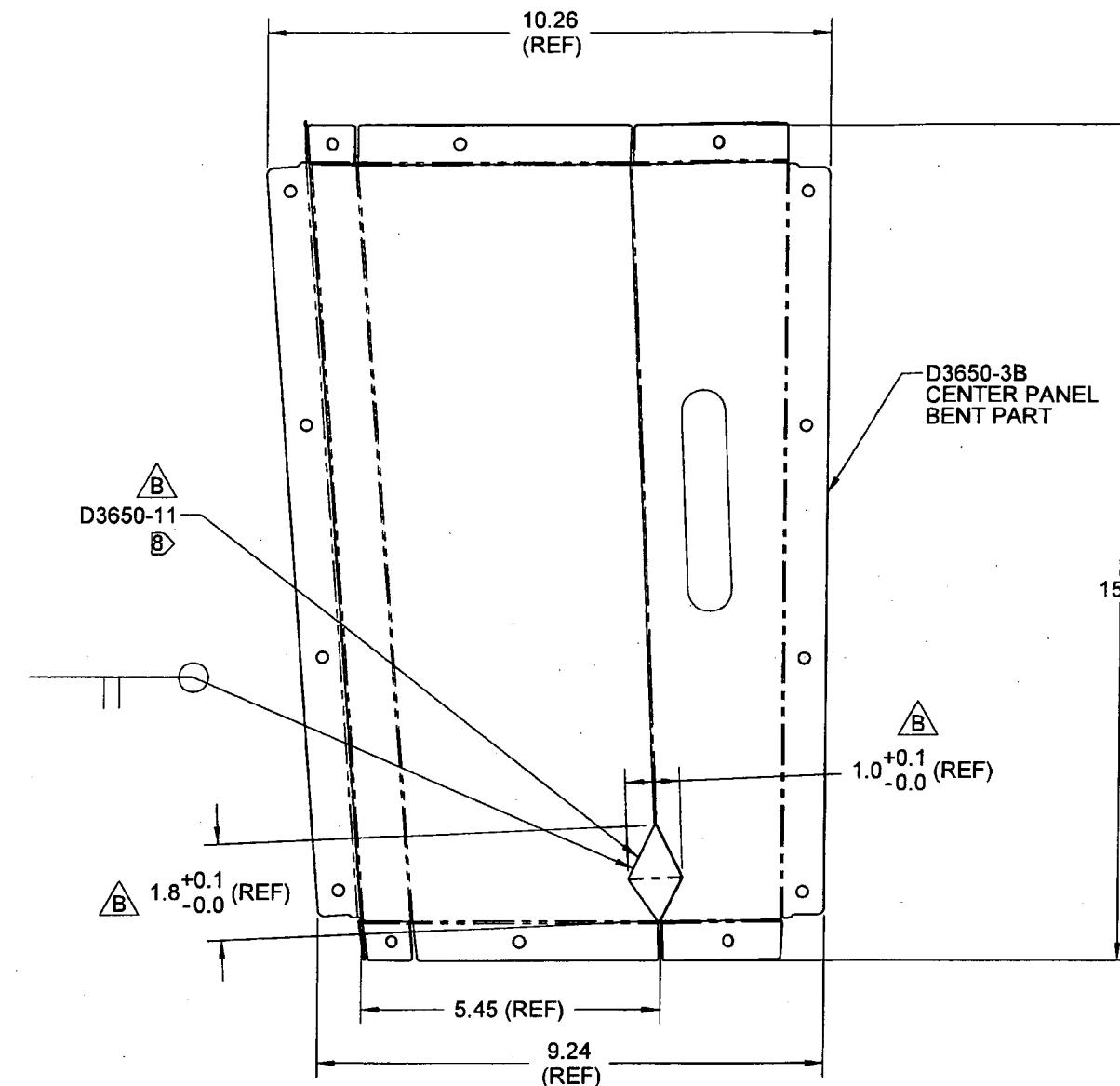
D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)



DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	<i>lu</i>	DRAWING NO. REV
MFG. APPR.	<i>AM</i>	D3650 SHEET 2
APPROVED	<i>MW</i>	TITLE SC
DE APPR.	<i>SH</i>	TOP PANEL ASSEMBLY
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT

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WITHOUT NOTICE
WORK ORDER
No. 42097

8 7 6 5 4 3 2 1



D3650-3 CENTER PANEL

RELEASED
08-03-27/07

NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	DA	D3650	SHEET 4 OF 9
APPROVED	MA	TITLE	RETURN TO
DE APPR.	MA	TOP PANEL ASSEMBLY	SCALE
DATE	08.01.07	1. ENGINEERING	
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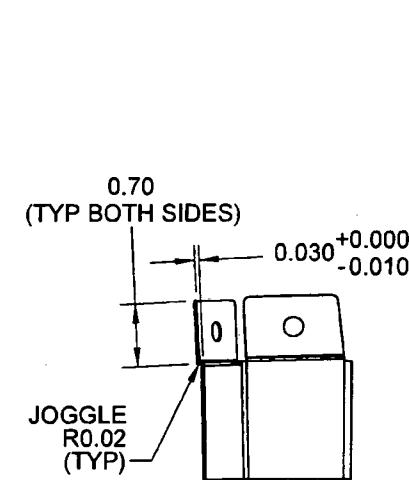
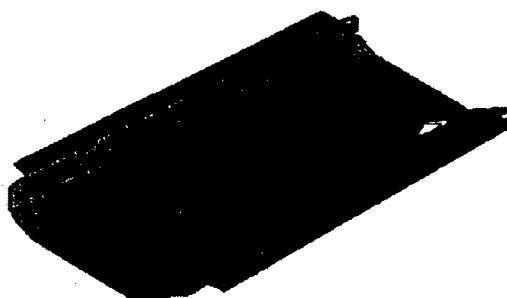
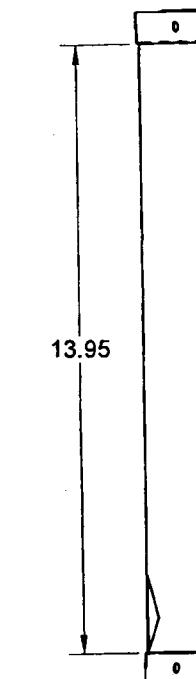
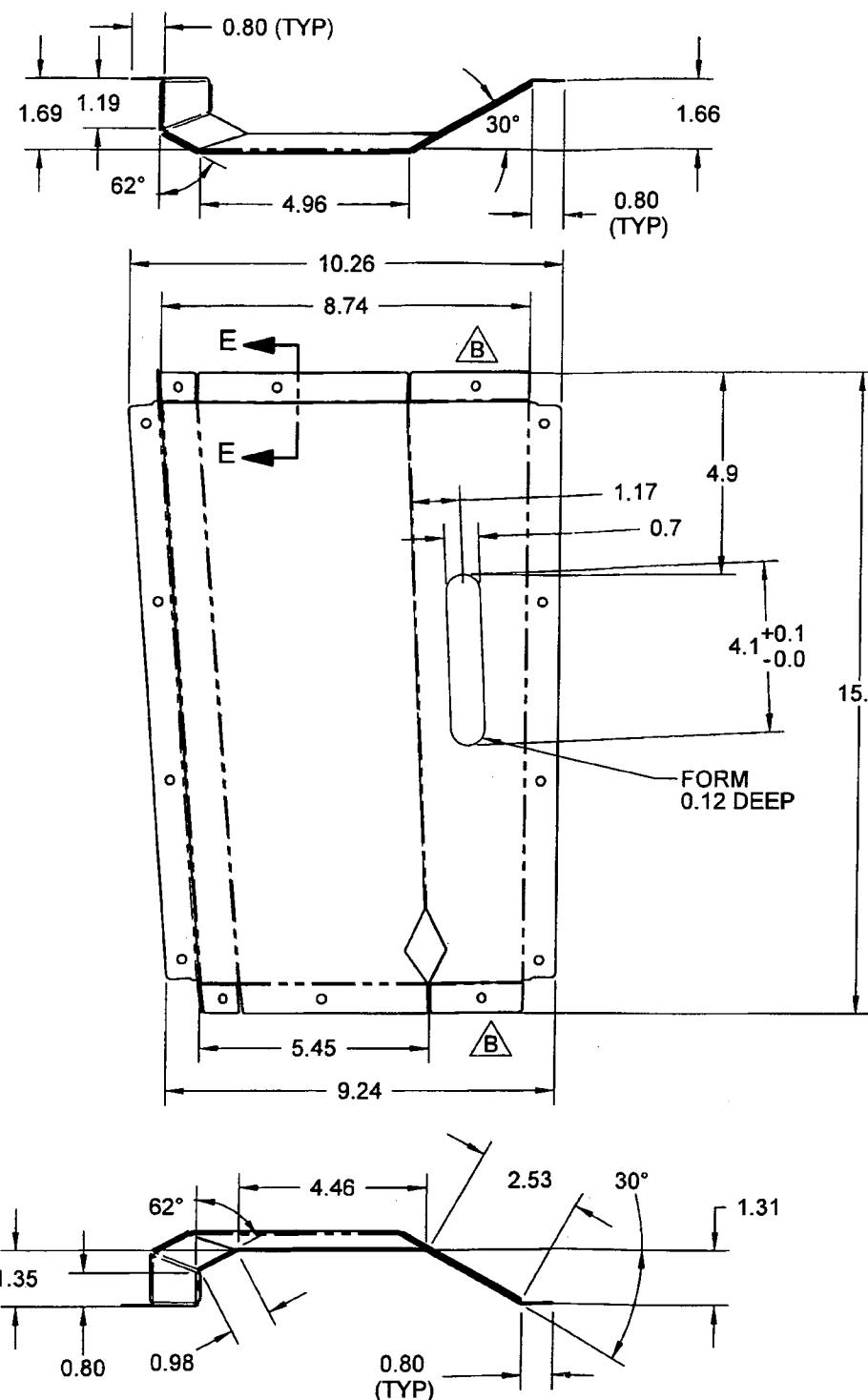
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WITHOUT NOTICE
WORK ORDER
NO. 4001

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**SECTION E-E**

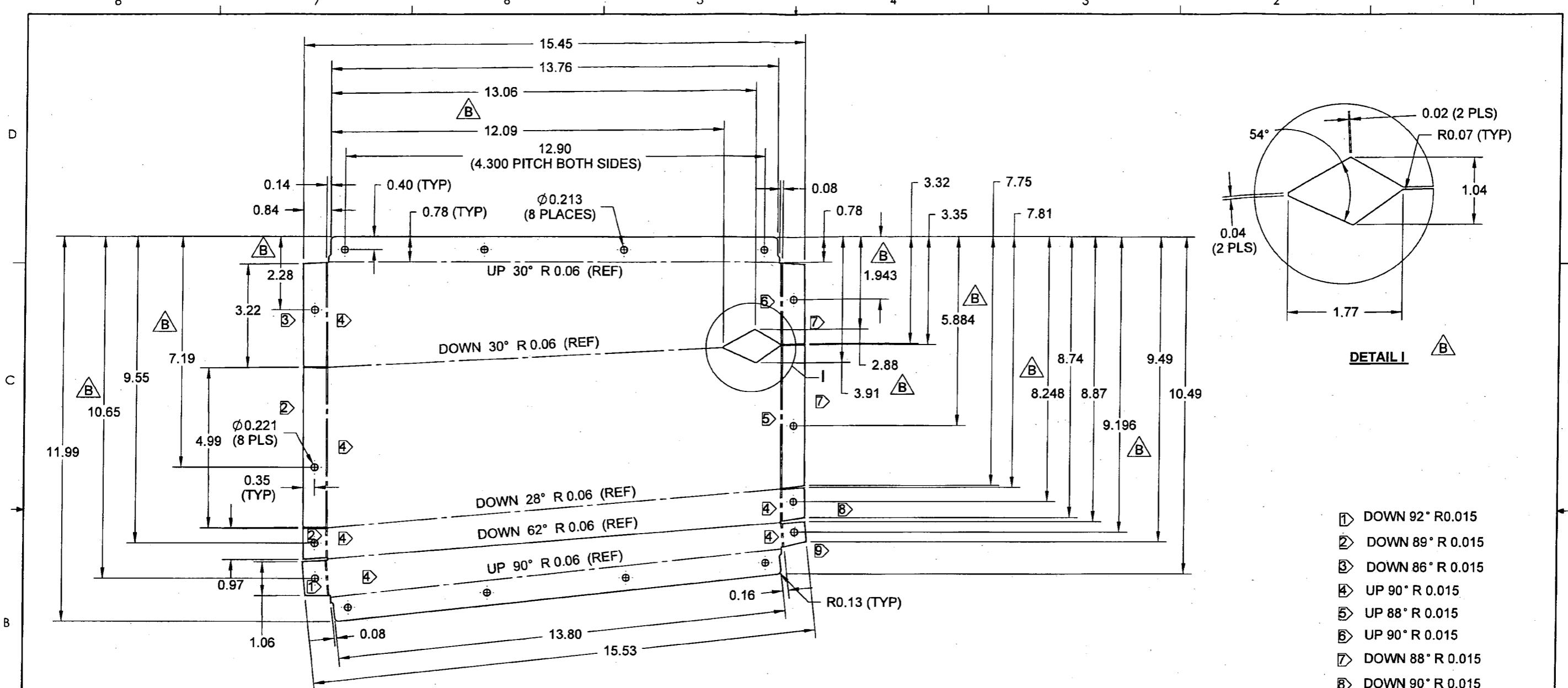
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08-03-27/10

NOTES:
 1) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
 (MAKE FROM D3650-3F FLAT PATTERN)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LC	DRAWING NO.	REV. B
MFG. APPR.	10	D3650	SHEET 5 OF 9
APPROVED	WY	TITLE	SCALE
DE APPR.	10	TOP PANEL ASSEMBLY	1.4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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D3650-3F CENTER PANEL FLAT PATTERN

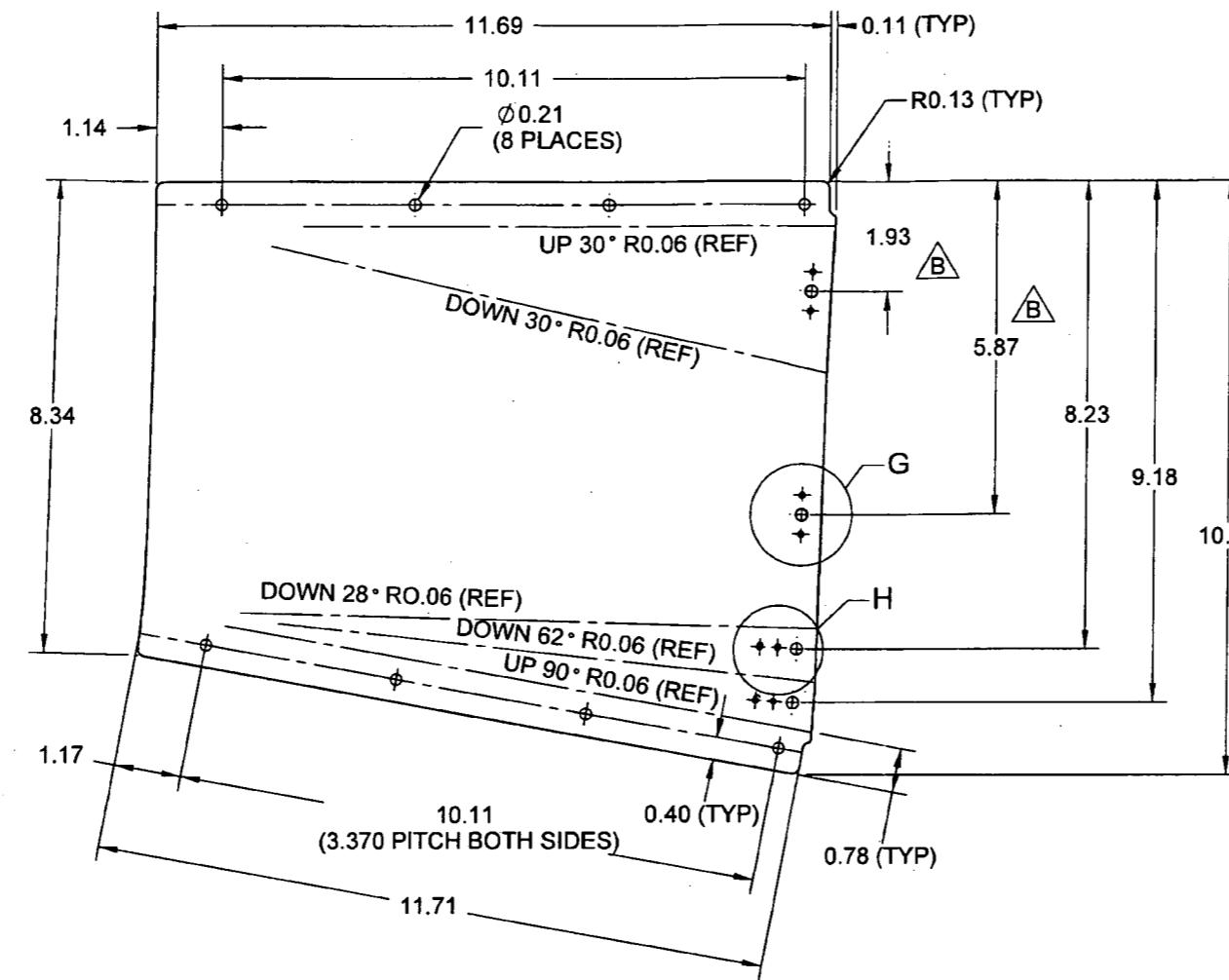
D3650-3F NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE

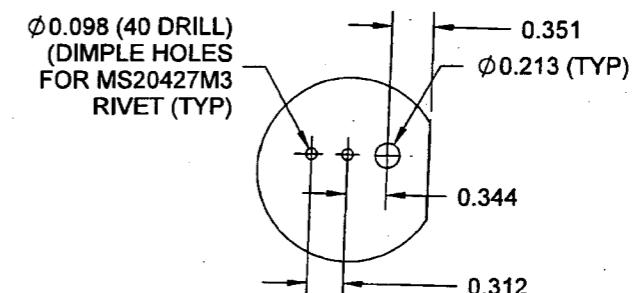
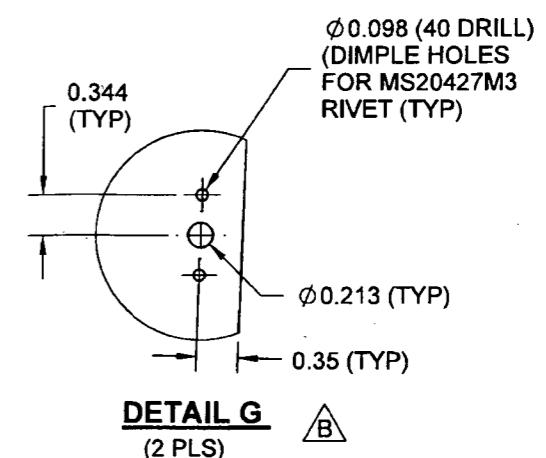
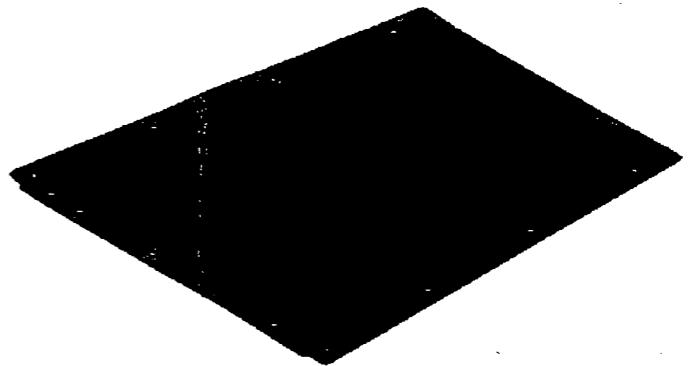
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>LE</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>AS</i>	D3650	SHEET 6 OF 9	
APPROVED	<i>WV</i>	TITLE	SCALE	
DE APPR.	<i>WV</i>	TOP PANEL ASSEMBLY	1:5	
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD		
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WORK ORDER



D3650-5F FLAT PATTERN



DETAIL H **WILL F A S**

NOTES

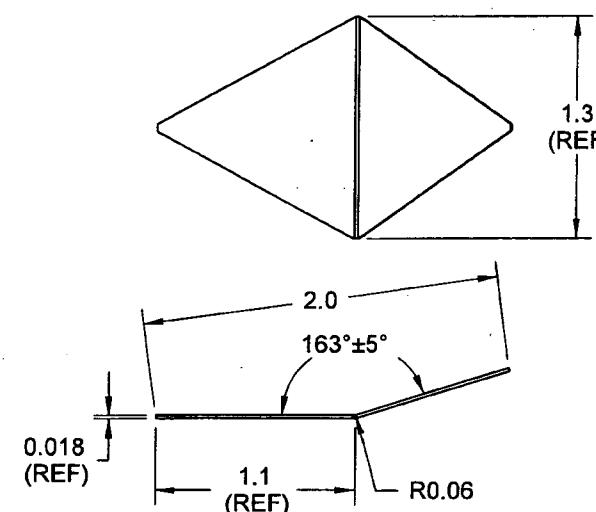
NOTE:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

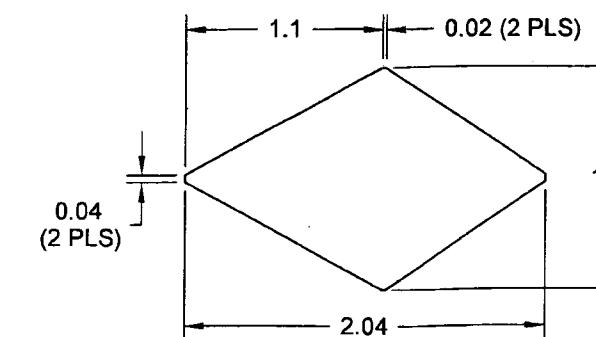
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>LE</i>	DRAWING NO.	REV.	
MFG. APPR.	<i>NA</i>	D3650	SHEET 8 OF	
APPROVED	<i>LM</i>	TITLE	SCALE	
DE APPR.	<i>SH</i>	TOP PANEL ASSEMBLY	1	
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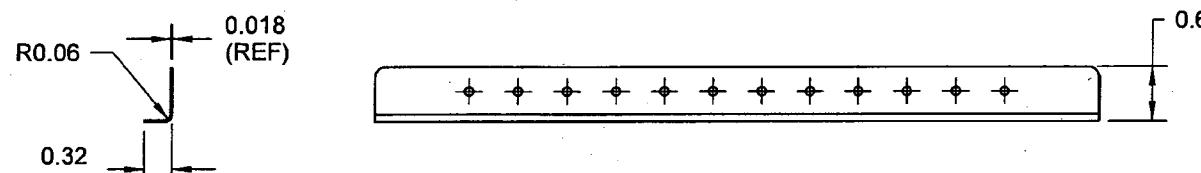
WITHOUT NOT
WORK ORDER
No. 9201



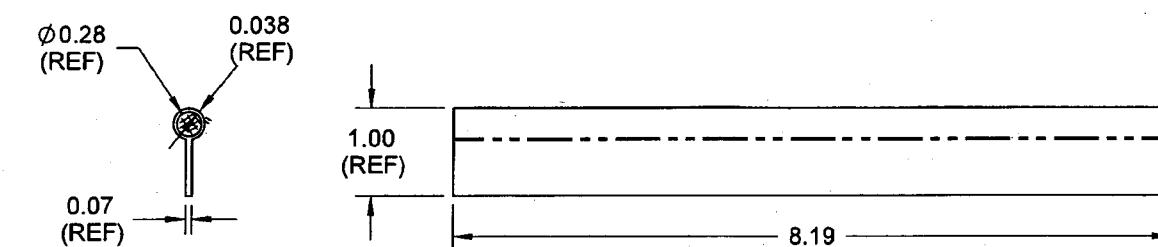
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)



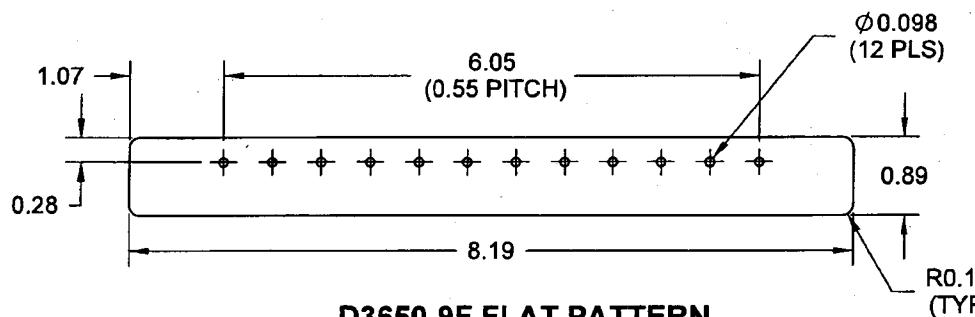
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-9 & D3650-11 NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

D3650-7-8.19 NOTES

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>LE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AM</i>	D3650	SHEET 9 OF 9
APPROVED	<i>LM</i>	TITLE	SCALE
DE APPR.	<i>SH</i>		
DATE	08.01.07	TOP PANEL ASSEMBLY	12 ENGINEERING
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